












Wednesday, 3/8/2006 10:37:51 AM

User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SHROUD ASSEMBLY
Job Number	: 26108 -1	Part Number	: D34675
Estimate Number	: 12219	Drawing Number	: D3467 REV.A
P.O. Number	: NIA	Project Number	: N/A
This Issue	: 3/8/2006 S.O. No. : NIA	Drawing Revision	: A
Prsht Rev.	: NC	Material	: NIA
First Issue	: NIA Type : PURCHASED PARTS	Due Date	: 3/31/2006
Previous Run	: NIA	Qty:	10 Um: Each
Written By	: <u>SAC COMMENT Below</u>		
Checked & Approved By	: <u>06.03.08</u>		
Comment	: est rev. A 06.02.06 new issue EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	OUTSIDE SERVICE	OUTSIDE SERVICES	
			
Comment: Sub-Contracting Issue P/O: <u>00000768</u> <u>06/03/09</u> Email or Ship DXF file to vendor Laser Cut per Dwg D3467 flat pattern D3467-5F Material release note required			
2.0	D34675F	AFT PLATE FLAT PATTERN	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) DOUBLER FLAT PATTERN			
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached			
4.0	QC6	DIMENSIONAL CHECK	
			
Comment: DIMENSIONAL CHECK			
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr SAP 06.03.22 (10) 2-Form as per dwg D3467 using DT8855			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/03/31
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHROUD ASSEMBLY

Job Number: 26108

Part Number: D34675

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



26.03.30 (4)



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

26.03.30 (4)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

26.03.30 (4)

Job Completion



26.03.30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 10:37:51 AM
 User: Kim Johnston

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SHROUD ASSEMBLY
 Job Number : 26108 -2
 Estimate Number : 12219
 P.O. Number : N/A Part Number : D34675
 This Issue : 3/8/2006 S.O. No. : N/A Drawing Number : D3467 REV.A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : A
 Previous Run : N/A Material : N/A
 Written By : SAL COMMENT BELOW Due Date : 3/31/2006 Qty: 10 Um: Each
 Checked & Approved By : 06.03.08
 Comment : est rev. A 06.02.06 new issue EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 OUTSIDE SERVICE OUTSIDE SERVICES



Comment: Sub-Contracting Issue P/O: 00000768 06/03/09
 Email or Ship DXF file to vendor
 Laser Cut per Dwg D3467 flat pattern D3467-5F
 Material release note required

2.0 D34675F AFT PLATE FLAT PATTERN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10000 Each(s)
 DOUBLER FLAT PATTERN

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage
 Ensure material certification is attached

06.03.22 (10)

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

06.03.22 (10)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr SAP 06.03.22 (10)

2-Form as per dwg D3467 using DT8855

06.03.23 (8) (10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	5	One Jaken Ser template	B	060323	1	B 04/04/26	B 060323

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: B Date: 06/04/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 10:37:51 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHROUD ASSEMBLY

Job Number: 26108

Part Number: D34675

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/04/25 (5)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

120604-25 (5)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

120604/26 (5)

Job Completion



120604.26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

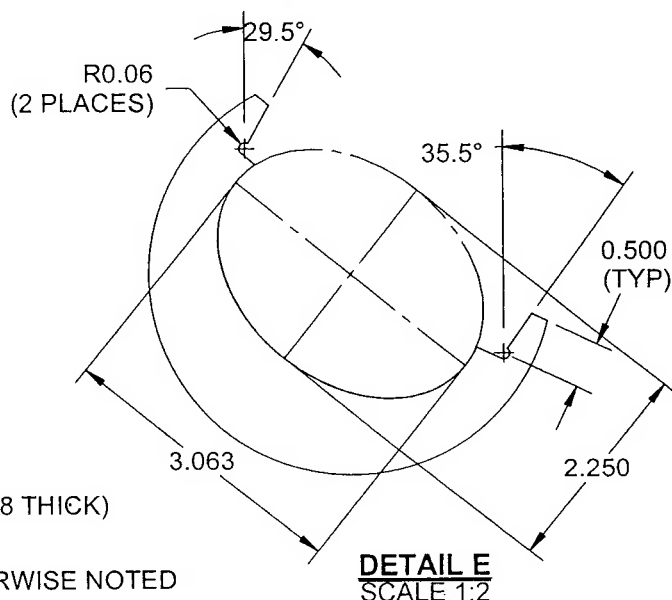
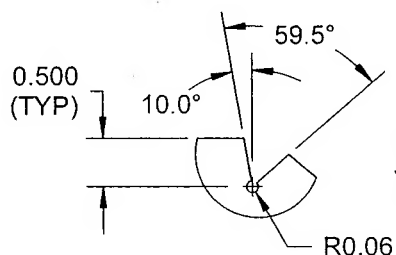
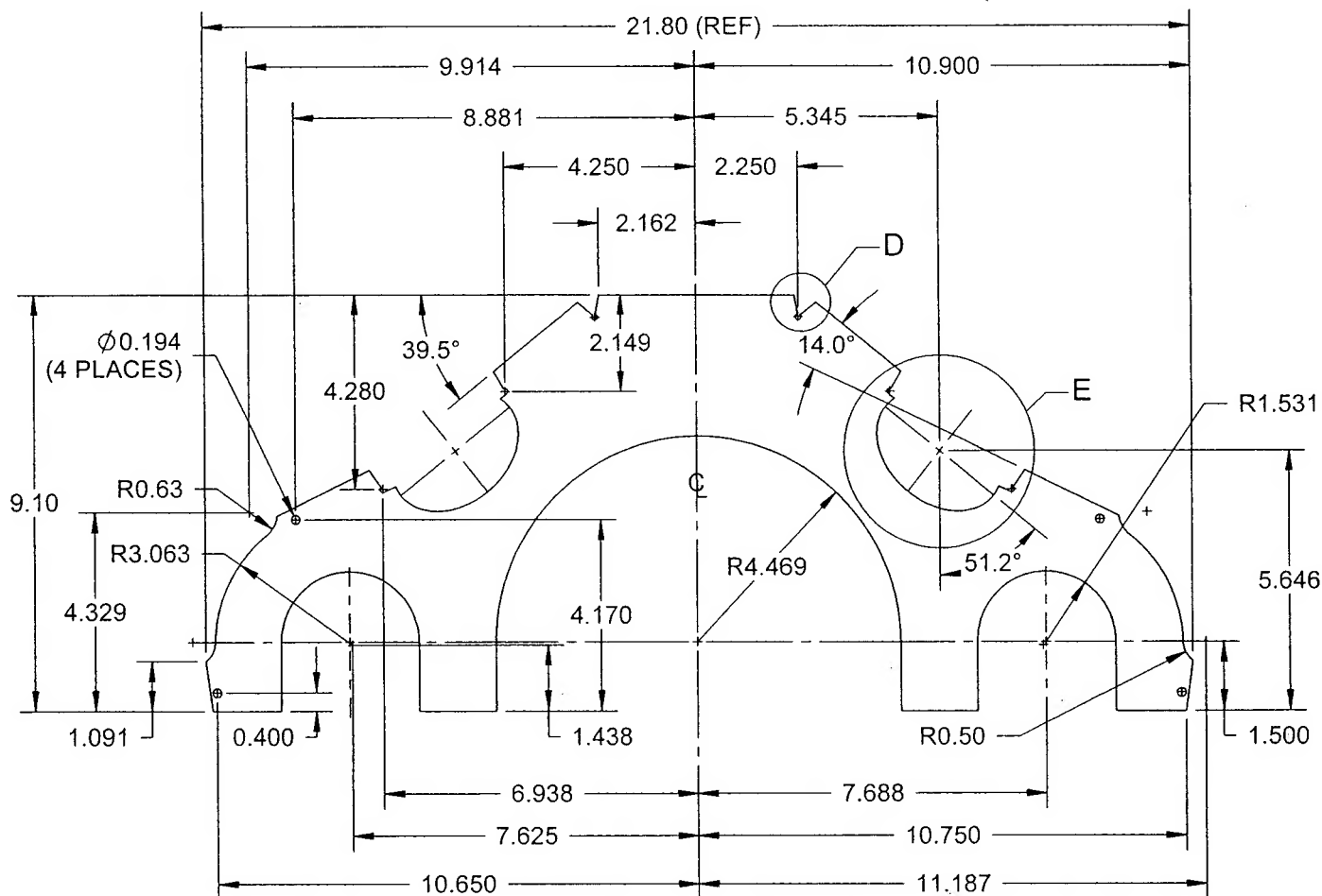
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3467	REV. A SHEET 8 OF 15
DATE 05.12.07		TITLE SHROUD ASSEMBLY	SCALE 1:8



D3467-5F AFT PLATE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019
(ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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4. 465
4. 469

8. 930

Fax Server

PAGE 001/002

3/17/2006 1:57

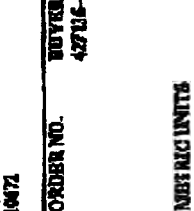
Ryerson

MAY-17-2005 16:05

FIELD INTERVIEW

8606-682-292

F-126 P-0007/016 F-687

		AK Steel Corporation		Page 1	
		Metallurgical Test Report Creston Works Creston, OH 43812			
CUSTOMER INTEGRIS METALS PO BOX 340 MINNEAPOLIS, MN 55440		INTEGRIS METALS 306 1 ST STREET AUBURN, WA 98001		PAINT NO. 74351497	
ORDER NO. 720713140		ORDER NO. 720713140		PROCESSOR ORDER NO. 427136-01	
PRODUCT 304 STAINLESS STEEL		PRODUCT 304 STAINLESS STEEL		PRODUCT 304 STAINLESS STEEL	
QUANTITY 1000 LBS		QUANTITY 1000 LBS		QUANTITY 1000 LBS	
COIL NO. 720713140		COIL NO. 720713140		COIL NO. 720713140	
COIL WEIGHT 1000 LBS		COIL WEIGHT 1000 LBS		COIL WEIGHT 1000 LBS	
COIL LENGTH 1000 FT		COIL LENGTH 1000 FT		COIL LENGTH 1000 FT	
COIL WIDTH 1000 IN		COIL WIDTH 1000 IN		COIL WIDTH 1000 IN	
COIL THICKNESS 1000 MIL		COIL THICKNESS 1000 MIL		COIL THICKNESS 1000 MIL	
COIL WEIGHT 1000 LBS		COIL WEIGHT 1000 LBS		COIL WEIGHT 1000 LBS	
COIL LENGTH 1000 FT		COIL LENGTH 1000 FT		COIL LENGTH 1000 FT	
COIL WIDTH 1000 IN		COIL WIDTH 1000 IN		COIL WIDTH 1000 IN	
COIL THICKNESS 1000 MIL		COIL THICKNESS 1000 MIL		COIL THICKNESS 1000 MIL	
COIL WEIGHT 1000 LBS		COIL WEIGHT 1000 LBS		COIL WEIGHT 1000 LBS	
COIL LENGTH 1000 FT		COIL LENGTH 1000 FT		COIL LENGTH 1000 FT	
COIL WIDTH 1000 IN		COIL WIDTH 1000 IN		COIL WIDTH 1000 IN	
COIL THICKNESS 1000 MIL		COIL THICKNESS 1000 MIL		COIL THICKNESS 1000 MIL	
COIL WEIGHT 1000 LBS		COIL WEIGHT 1000 LBS		COIL WEIGHT 1000 LBS	
COIL LENGTH 1000 FT		COIL LENGTH 1000 FT		COIL LENGTH 1000 FT	
COIL WIDTH 1000 IN		COIL WIDTH 1000 IN		COIL WIDTH 1000 IN	
COIL THICKNESS 1000 MIL		COIL THICKNESS 1000 MIL		COIL THICKNESS 1000 MIL	
COIL WEIGHT 1000 LBS		COIL WEIGHT 1000 LBS		COIL WEIGHT 1000 LBS	
COIL LENGTH 1000 FT		COIL LENGTH 1000 FT		COIL LENGTH 1000 FT	
COIL WIDTH 1000 IN		COIL WIDTH 1000 IN		COIL WIDTH 1000 IN	
COIL THICKNESS 1000 MIL		COIL THICKNESS 1000 MIL		COIL THICKNESS 1000 MIL	
COIL WEIGHT 1000 LBS		COIL WEIGHT 1000 LBS		COIL WEIGHT 1000 LBS	
COIL LENGTH 1000 FT		COIL LENGTH 1000 FT		COIL LENGTH 1000 FT	
COIL WIDTH 1000 IN		COIL WIDTH 1000 IN		COIL WIDTH 1000 IN	
COIL THICKNESS 1000 MIL		COIL THICKNESS 1000 MIL		COIL THICKNESS 1000 MIL	
COIL WEIGHT 1000 LBS		COIL WEIGHT 1000 LBS		COIL WEIGHT 1000 LBS	
COIL LENGTH 1000 FT		COIL LENGTH 1000 FT		COIL LENGTH 1000 FT	
COIL WIDTH 1000 IN		COIL WIDTH 1000 IN		COIL WIDTH 1000 IN	
COIL THICKNESS 1000 MIL		COIL THICKNESS 1000 MIL		COIL THICKNESS 1000 MIL	
COIL WEIGHT 1000 LBS		COIL WEIGHT 1000 LBS		COIL WEIGHT 1000 LBS	
COIL LENGTH 1000 FT		COIL LENGTH 1000 FT		COIL LENGTH 1000 FT	
COIL WIDTH 1000 IN		COIL WIDTH 1000 IN		COIL WIDTH 1000 IN	
COIL THICKNESS 1000 MIL		COIL THICKNESS 1000 MIL		COIL THICKNESS 1000 MIL	
COIL WEIGHT 1000 LBS		COIL WEIGHT 1000 LBS		COIL WEIGHT 1000 LBS	
COIL LENGTH 1000 FT		COIL LENGTH 1000 FT		COIL LENGTH 1000 FT	

Fax Server

T-726 P.008/015 F-527

002/004

MATERIAL TEST REPORT

From: NORTH AMERICAN STAINLESS CANADA, IN
740 IMPERIAL ROAD NORTH

Page : 1
Heat/Lot : 86K8
TIN : B42748

Sold To: INTEGRIS METALS, LTD.
7910 40TH STREET SE
CALGARY, AB T2C2Y3

Ship To: ***CUSTOMER PICKUP***
4375 14TH STREET NORTHEAST
CALGARY
ABT3E7A9

Vendor Information

Cust PO #: 406824

Cust PO DT: 11/03/05

Specifications

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.
ASTMA240/04a 480/04a, 666/03, ASME SA240/04-A05, 480/04-A05, SA666/04
Q08766D-A X 1/8 PRM, AMS5513H X MRK&FIN, MIL5059D, AMD3, X CRWN MEAS
CORROSION: ASTM A262/02aB; 180Bend-OK

Buyer Part: 4288441

304 2B .1305 IN 48 IN 96 IN

Country of Origin: UNITED STATES

Mechanical Tests

		UOM	L	O		UOM	L	O
Yield Strength - 0.2% Offset	40	KSI	F	TRANSV				
Tensile Strength (UTS)	93.3	KSI	F	TRANSV				
Rockwell B	85		F	TRANSV				
Pct Uniform Elong 2 In/50mm	57.01	PCT	F	TRANSV				
Rockwell A	85		T	TRANSV				

Chemical Composition

C Carbon-Pct	.059	CR Chromium-Pct	18.360
CU Copper-Pct	.342	MN Manganese-Pct	1.643
MO Molybdenum-Pct	.285	N Nitrogen-Pct	.037
NI Nickel-Pct	8.150	P Phosphorus-Pct	.029
SI Silicon-Pct	.289		

Comments

1001

003/004

004

INDUSTRIAL LASER CUTTING
INTEGRIS METALS

03/17/2006 14:37 FAX 604 946 4153
04/20/2015 08:27 FAX

MATERIAL TEST REPORT

From: NORTH AMERICAN STAINLESS CANADA, IN
740 INDUSTRIAL ROAD NORTH

Page : 2
Heat/Lot : 86K9
TIN : B42748

Material free from mercury contamination. No weld repairs.
EN 10204 3.1 PED 97/23/EC Annex1, Para. 4.3 Q08763F Cond A
This document certifies the material has been tested in
accordance with applicable specifications described herein
and has met those requirements.

QA by ERIC HESS 02/01/2006

Miscellaneous Data

GUKLEH, ONN K123
Control #: 90C60214
Part #: 74270441
.135 X 48 X 96

Date: 03/17/06

SOLD TO: INDIAN LAZER

TO 110880

S/P 90-374786 - 02

[Signature] 3/17/06

The Chemical Analysis and Mechanical Test
data was received via EDI from the above
mentioned vendor.

INTEGRIS METALS, LTD.

Date: Friday, 6/2/2006 11:44:18 AM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D3467-1/-2/-5/-9/-15/-17
Job Number : 27328	
Estimate Number : 10804	
P.O. Number : NIA	Part Number : Z_CUSTOM
This Issue : 6/2/2006 S.O. No. : NIA	Drawing Number : REWORK
Prsht Rev. : NC	Project Number : NIA
First Issue : NIA Type : NIA	Drawing Revision : NIA
Previous Run : 00015	Material : NIA
Written By : SEE COMMENT BELOW	Due Date : 6/9/2006 Qty: 1 Um: Each
Checked & Approved By : SEE ABOVE USER & DATE	
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

REMOVE THE FOLLOWING PARTS FROM STOCK AND REWORK
 PER DRWG D3467 REV.B

D3467-1/-2 B _____ OPEN HOLES AT .250 ✓

D3467-5/B _____ OPEN HOLES AT .203

D3467-9 B _____ OPEN HOLES AT .250

D3467-15 B _____ OPEN HOLES AT .250

D3467-17 B _____ OPEN HOLES AT .250 ✓

-1 B 26629 -2 B 26980

B 26108-2

no hole dimension change

B 2614

SB 06/06/03

2.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

J 06-06-06

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

RESTOCK PARTS USING ORIGINAL B/N

57446

06/06/06

4.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL
 INSPECT LEVEL 21

NOTE: ADD A COPY OF THIS W/O TO EACH P/N ABOVE

06/06/07

Job Completion



U 06/06/07